

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS			
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Crosstube	Water Jet	Engineering
NCR No. _____	Suspected	Unapproved		Machining	Small Fab	Prod. Eng. Coor.	Quality
				Thermoforming	Finishing	Rec/Store/Packaging	Other
				Large Fab	Composite	Supplier	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
	Bending		Bend		Folio/Program		Outside Dimensions		Pressure/Forced		
	Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance		Set-up		
	Cracks		Broken/Damage/Defect		Hardware		Part Incorrect		Temperature/Cure		
	Crimp/Kink/Ripple/Wave		Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing		Weld		
	Cuffs		Contamination		Instructions Incomplete/Unclear		Part Moved		Wrong Stock Pulled		
	Crushing		Countersink		Misaligned/off center		Positioned Wrong				
	Heat Treat		Cut Too Short		Mislabeled		Power Loss/Surge		Other		
	Inspection Strip in Tube		Drawing		Misread						
	Marks/Chatter		Drill Holes		Off-set						
	Turning Sequence		Finish		Out of Calibration						
	Wave/Twist in Tube		Fit/Function		Out of Sequence						

Work Order ID 116815

April-24-14 7:46:56 AM

116815

Page 2

Item ID: D3564-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Stainless Steel Wearplate Center Aft

Stop

NS2

Start Date: 5/05/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

DAS
36
9-89

4/6/14/72

130

130

Brake NC

NC BRAKE

0.00

DAS

30

9-89

13

Brake NC

Memo

0.00

Deburr if necessaryForm on Brake as per Dwg D3564 using Jigs DT8179 and
DT8155Form Joggle as per Dwg D3564 on brake using Jig DT8157

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

SPW
MS/23

B

150

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME: 230 OVEN TEMPERATURE:
FINISH TIME: 3:00

13 4/14-5-26.

0459

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Crosstube	Water Jet	Engineering		
NCR No. _____	Suspected	Unapproved		Machining	Small Fab	Prod. Eng. Coor.	Quality		
				Thermoforming	Finishing	Rec/Store/Packaging	Other		
				Large Fab	Composite	Supplier			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General									
	Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced					
	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up					
	Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure					
	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld					
	Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled					
	Crushing	Countersink	Misaligned/off center	Positioned Wrong						
	Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other					
	Inspection Strip in Tube	Drawing	Misread							
	Marks/Chatter	Drill Holes	Off-set							
	Turning Sequence	Finish	Out of Calibration							
	Wave/Twist in Tube	Fit/Function	Out of Sequence							

Work Order ID 116815

April-24-14 7:46:56 AM

116815

Page 3

Item ID: D3564-5

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Stainless Steel Wearplate Center Aft

Stop

NS2

Start Date: 5/05/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

SPM

160

QC

Quality Control

4/18/06

13

170

Identify as per dwg & Stock Location: FP-002 0.00

170

Packaging

Packaging

0.00

x13 d HL wos(2)

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Quality Control

0.00

MJ 14-05-28

AM 4-08-26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

<p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p>			DISPOSITION <input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved		AGAINST DEPARTMENT/PROCESS <input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other								
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
FAULT CATEGORY													
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function				<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence				<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Picklist Print

April-24-14 7:47:00 AM

Page 1

Work Order ID: 116815

116815

Parent Item: D3564-5

D3564-5

Parent Item Name: Stainless Steel Wearplate Center Aft

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A	New Issue 07-03-08	ec
IPP Rev:B	As per Rev C	07-07-09 JLM
IPP Rev:C	As per Rev D	07-09-09 JLM Verified By:EC
IPP Rev D	added DT# 08.04.21	DD Verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	123.2670	1.5	19		**	

M304S16GA

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	123.267	
M126915	0.737	
M127821	122.53	

129192

129192

JM14-05-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
 Machining
 Thermoforming
 Large Fab

Crosstube
 Small Fab
 Finishing
 Composite

Water Jet
 Prod. Eng. Coor.
 Rec/Store/Packaging
 Supplier

Engineering
 Quality
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General															
	<input type="checkbox"/>	Bending	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced								
	<input type="checkbox"/>	Centre Not Concentric	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up								
	<input type="checkbox"/>	Cracks	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure								
	<input type="checkbox"/>	Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld								
	<input type="checkbox"/>	Cuffs	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled								
	<input type="checkbox"/>	Crushing	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>									
	<input type="checkbox"/>	Heat Treat	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>									
	<input type="checkbox"/>	Inspection Strip in Tube	<input type="checkbox"/>	Misread	<input type="checkbox"/>		<input type="checkbox"/>									
	<input type="checkbox"/>	Marks/Chatter	<input type="checkbox"/>	Off-set	<input type="checkbox"/>		<input type="checkbox"/>									
	<input type="checkbox"/>	Turning Sequence	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>									
	<input type="checkbox"/>	Wave/Twist in Tube	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>									

DART AEROSPACE LTD	Work Order:	116815
Description: Wearshoe	Part Number:	D3564-5
Inspection Dwg: D3564 Rev: D		Page 1 of 1

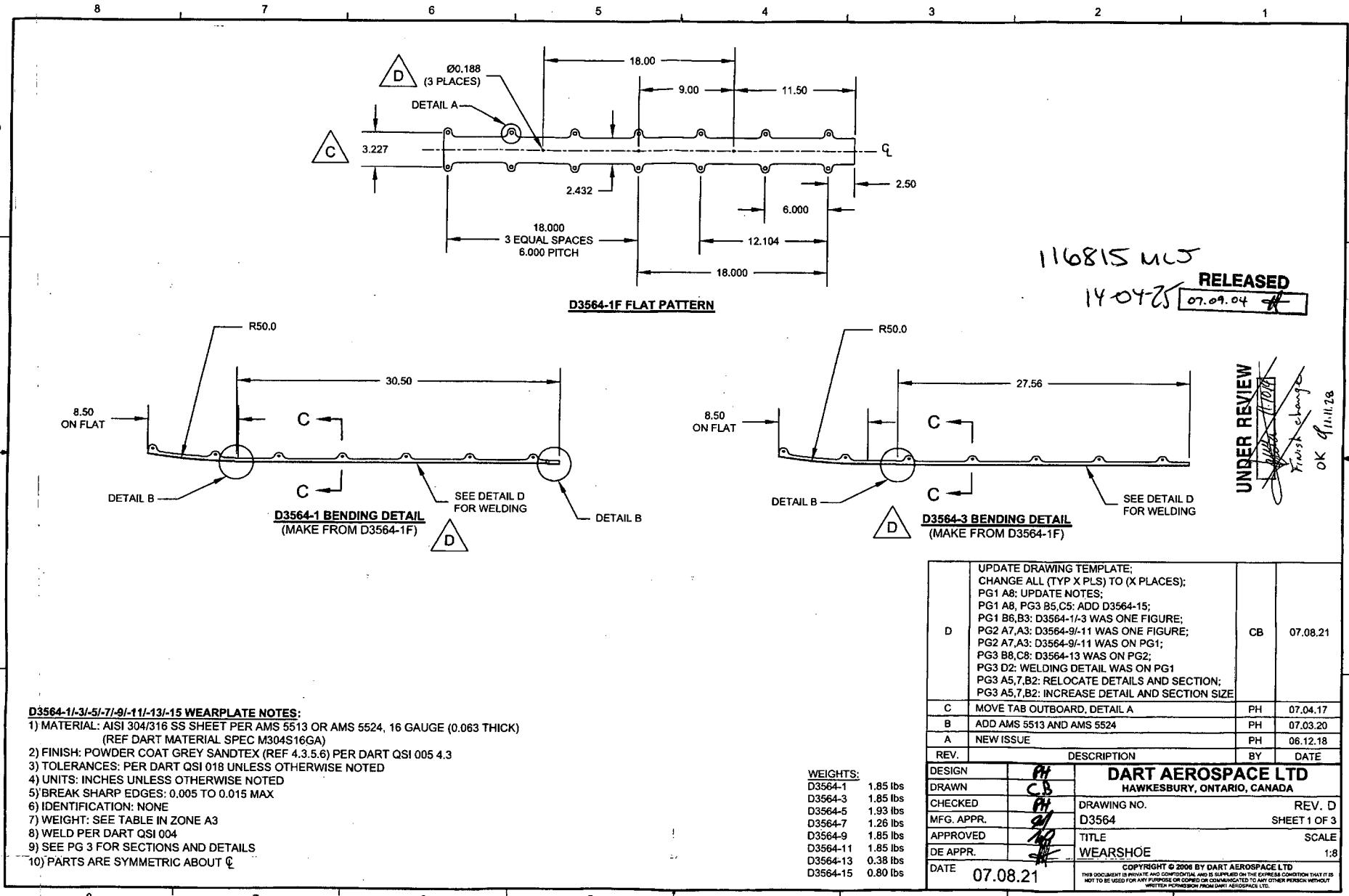
FIRST ARTICLE INSPECTION CHECKLIST

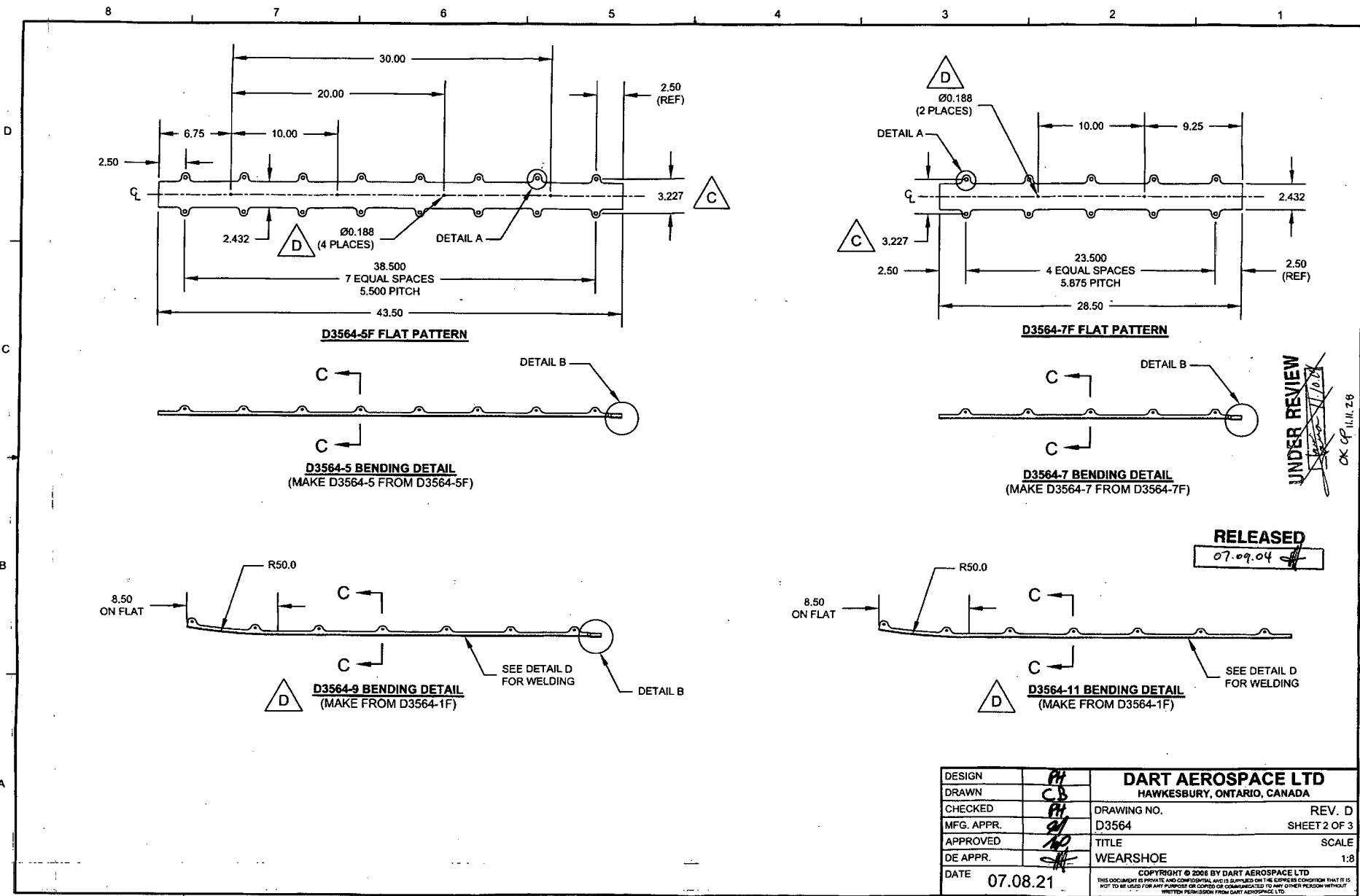
X First Article Prototype

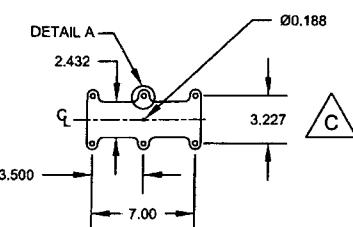
DAS

Measured by:	<u>MM/JM</u>	Audited by:	<u>27</u> <small>Q.S.P.</small>	Prototype Approval:	N/A
Date:	<u>14/05/17</u>	Date:	<u>14/5/20</u>	Date:	N/A

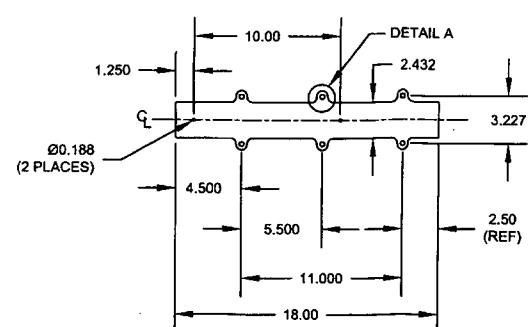
Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	



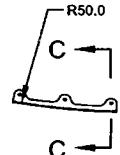




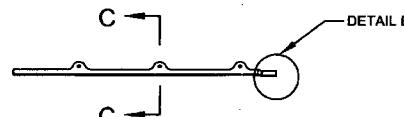
D3564-13F FLAT PATTERN



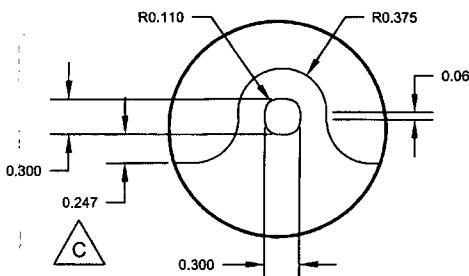
D3564-15F FLAT PATTERN



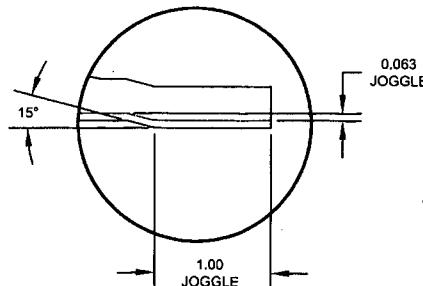
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



DETAIL A

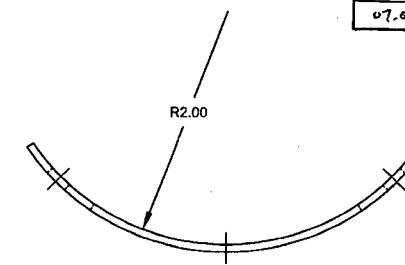


DETAIL B

2059B HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH
(11 PLACES)
WELD AFTER BENDING AS ILLUSTRATED PER DT8308

DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

RELEASED
07.09.04



SECTION C-4
SCALE 1:1

~~UNDER REVIEW~~ 11/10/94
OK 11/10/94

DESIGN	PH	DART AEROSPACE LTD		
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA		
CHECKED	PH	DRAWING NO.	REV. D	
MFG. APPR.	SI	D3564	SHEET 3 OF 3	
APPROVED	NO	TITLE	SCALE	
DE APPR.	SI	WEARSHOE	1:1	
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		

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